

Date: Wednesday, 25/06/2008 10:02:04 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER RESTRAINT WELDMENT
Job Number	: 40064		
Estimate Number	: 13398		
P.O. Number	:	Part Number	: PB674300131
This Issue	: 25/06/2008 S.O. No. :	Drawing Number	: B6743001 P.41/ P.43
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 04/07/2008
Checked & Approved By	: <u>JLD 08.06.25</u>	Qty:	5 Um: Each
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s)
6061-T6 .090 Sheet
batch: 108595 B 8-7-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001 - 321 08.06.25
Dwg Rev: B1 B 8-7-15 (6)
Prog Rev: B1
***grain direction along 25.00" ***
2-Deburr if necessary B 8-7-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/7/15 (46)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg B67-43001

SB 08/07/16 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 10:02:04 AM
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Process Sheet

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02 07/16 (46)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.3

08/07/16 (60)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

7:10 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

7:40 AM

08-07-17

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-17

10.0

PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Upper Pad Assembly

batch: 40294

08-08-26

11.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

batch: 10870

08-08-26

12.0

MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 25.0000 Each(s)

Screw

batch: 18057

08-08-26

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg B67-43001

08-08-26 5

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/26 (XS)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Handwritten signature and initials

16.0

QC21

FINAL INSPECT

RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



Handwritten signature and date 08/08/26

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

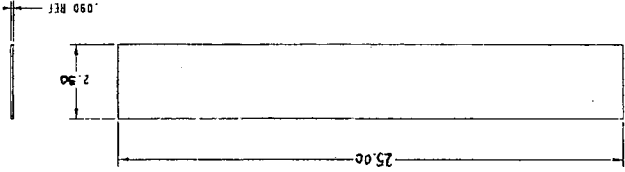
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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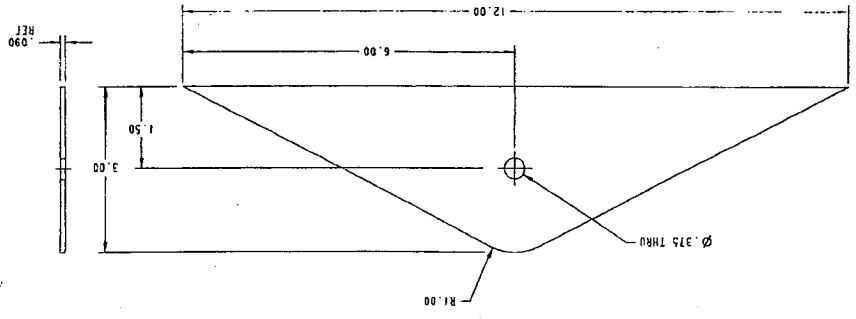
ORIGINAL

PREMIER AVIATION, INC.
3002 AVIATION PARKWAY, CHESAPEAKE, VIRGINIA 20042
DLSUV8 B67-43001

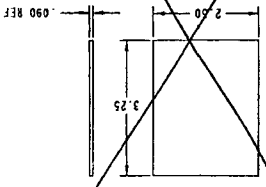
① -321 PLATE
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
OO-A-200/8



② -319 GUSSET
SCALE 1.000
MAT: .090 THK 6061-T6 AL.
OO-A-200/8

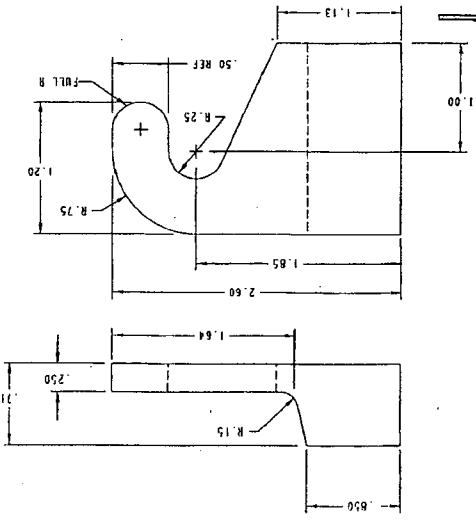


② -317 PLATE
SCALE 0.750
MAT: .090 THK 6061-T6 AL.
OO-A-200/8

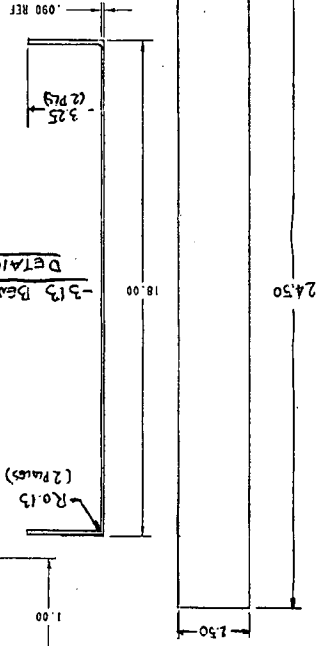


SUPERCEDED BY
NEW PART OF -317

③ -315 HOOK
SCALE 2.000
MAT: 6061-T6 AL.
OO-A-200/8



① -313 FLAT PATTERN
SCALE 0.500
MAT: .090 THK 6061-T6 AL.
OO-A-200/8



RELEASED
10-01-70

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40084

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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